

# Work Order ID 66829

Monday, February 28, 2011 11:40:00 AM



Page 1

Item ID: D3183-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 2/28/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*H*

Date:

*11-02-28*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3183	Rev C1

100

0.00



BAND SAW

Bandsaw

Memo

0.00

*end 11/03/10*

*4* *0*

Jeaspa Bandsaw

Cut blanks: (1.500" x 2.250") 5.500" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

*end 11/03/15*

*4* *0*

*(PTO)*

HAAS CNC vertical machine #1

1-Machine D3183-3 as per Folio FA322 and Dwg D3183 Identify as D3183-3  
3-Debur 3-Scribe batch number

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00




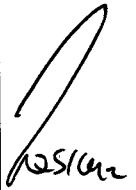
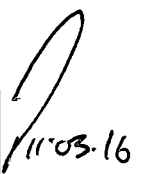
*end 11/03/15*

*0* *0*

Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3183-043 PAR #: \_\_\_\_\_ Fault Category: Machinery NCR: Yes No DQA: \_\_\_\_\_ Date: 11/03/16  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: \_\_\_\_\_ Date: 11/4/17

NCR: 66829		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/03/11	110	1 part scrap, part pop out of the jig, try to re-run part but the floor are not straight.		scrap and destroy replen Qty: 1 Batch # 11115806	 11/03/15	 11/03/16		 11-03-16
		R.C. poor tooling						

NOTE: Date & initial all entries

**Work Order ID 66829**

Monday, February 28, 2011 11:40:00 AM



Page 2

Item ID: D3183-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 2/28/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		JL 11/03/16		(4)			
140  Small Fab Small Fab	Small Fab  Memo Assemble D3183-043 as per Dwg D3183.	0.00  0.00		SB 11/04/16		(4)			
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		S. 11/04/16		(4)			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66829**

Monday, February 28, 2011 11:40:00 AM

Page 3

Item ID: D3183-043

Accept

Revision ID:

Item Name: Bracket Assembly

Start Date: 2/28/2011 Start Qty: 4.00

Required Date: 3/4/2011 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Identify as per dwg & Stock Location: 236

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

2/28/11 (7)

2/28/11

D3183-043 (H)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, February 28, 2011 11:40:06 AM

Page 1

Work Order ID: 66829

Parent Item: D3183-043

Parent Item Name: Bracket Assembly




Start Date: 2/28/2011

Required Date: 3/4/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:Pick:A 04.02.18 New issue KJ/DS  
IPP Rev:B Changed Mat Size 08-06-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3183-045  Bearing Assembly		Manufactured	No			100	Each	2.0000	2	8			
<div> <div>Location</div> <div>ST236</div> <div>63989</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>867520</div> </div> <div> <div>Loc Code</div> <div>7</div> <div></div> </div>													
D3121-21  Bolt		Manufactured	No			140	Each	16.0000	2	8			
<div> <div>Location</div> <div>ST235</div> <div>57376</div> <div>65659</div> </div> <div> <div>Loc Qty</div> <div>16</div> <div>1</div> <div>15</div> </div> <div> <div>Loc Code</div> <div>866969</div> <div></div> <div></div> </div>													
M174B1.500X02.250  17-4 SS Bar 1.50 X2.250		Purchased	No			140	f	36.3050	0.4583	1.929684			
<div> <div>Location</div> <div>MAT</div> <div>115806</div> <div>MAT031</div> <div>108309</div> <div>113568</div> </div> <div> <div>Loc Qty</div> <div>25.16</div> <div>25.16</div> <div>11.14496</div> <div>1</div> <div>10.14496</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>													

1.929 ml 1/103/10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 44829
<b>Description:</b> Bracket		<b>Part Number:</b> D3183-3
<b>Inspection Dwg:</b> D3183	<b>Rev:</b> C1	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	R.188	—		Red-gage	
R0.063	+/-0.010	R.063	—		"	
0.182	+/-0.010	.182	—		Vern ML-7	
0.070	+/-0.010	.072	—		"	
0.100	+/-0.010	.103	—		"	
Ø0.201 x 0.100	+/-0.010	Ø.199 X .092	—		"	
0.182	+/-0.010	.180	—		"	
5.32	+/-0.030	5.325	—		"	
5.036	+/-0.010	5.034	—		High gage 31006	
2.120	+/-0.010	2.120	—		Vern ML-7	
1.290	+/-0.010	1.290	—		"	
0.365	+/-0.010	.365	—		"	
0.218	+/-0.010	.212	—		"	
1.030	+/-0.010	1.030	—		"	
1.90	+/-0.030	1.888	—		"	
1.012	+/-0.010	1.006	—		"	
Ø0.201 x 0.100	+/-0.010	Ø.200 X .097	—		"	
0.786	+/-0.010	.782	—		"	
Ø0.392	+0.002/-0.000	Ø.393	—		"	
R0.19	+/-0.030	R.190	—		"	
3.954	+/-0.010	3.956	—		High gage 31006	
0.162	+/-0.010	.160	—		Vern ML-7	
R0.19	+/-0.030	R.190	—		Red-gage	
R0.25	+/-0.030	R.250	—		"	
4.26	+/-0.030	4.265	—		Vern ML-7	
2.080	+/-0.030	2.110	—		"	
1.155	+/-0.010	1.155	—		"	
0.162	+/-0.010	.162	—		"	
0.36	+/-0.030	.360	—		"	
0.615	+/-0.010	.613	—		"	
0.435	+/-0.010	.432	—		"	
0.200	+/-0.010	.200	—		"	
0.381	+/-0.010	.381	—		"	
0.032	+/-0.010	.030	—		Depth gage ML-05	

<b>Measured by:</b> JNL	<b>Audited by:</b> JNL	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11/03/15	<b>Date:</b> 11/03/16	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3183-043	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	06.03.09	Dwg Rev update	KJ/JLM	
D	08.01.28	0.182 dimension removed	KJEC/DD	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

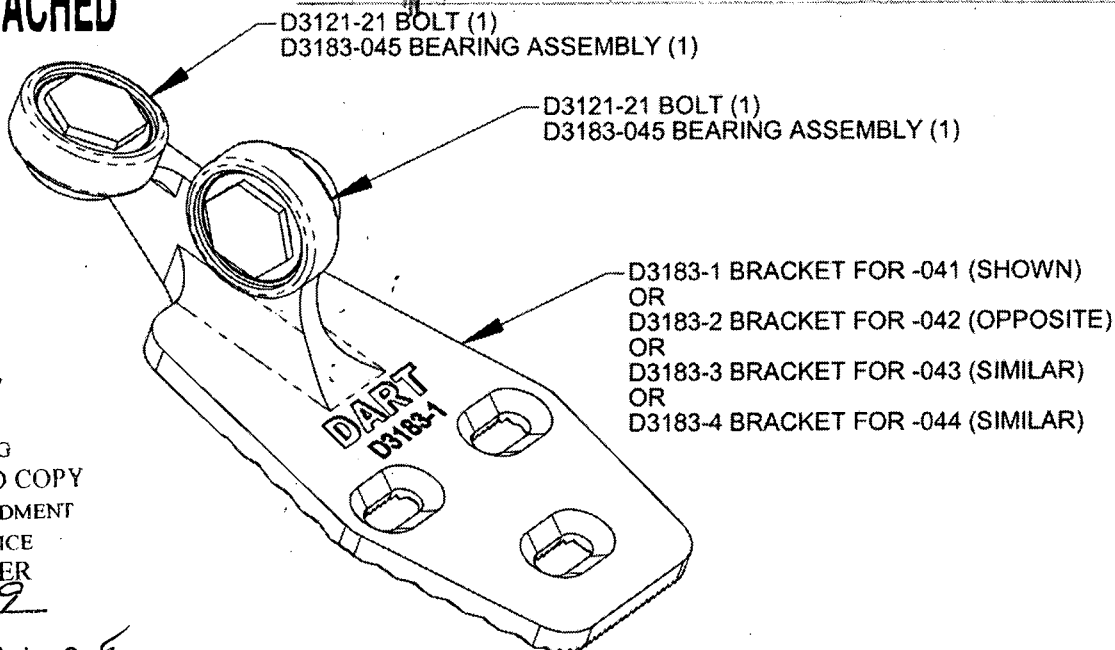


DESIGN #	DRAWN BY CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3183</b>	REV. C SHEET 1 OF 4
DATE <b>04.02.17</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
C1	# 04.11.09	0.830 WAS 0.850	

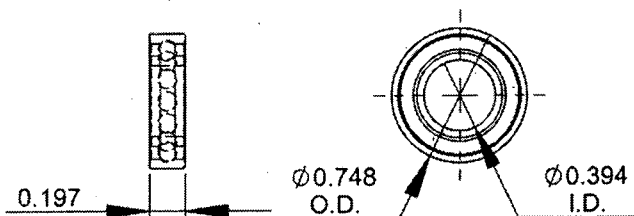
**RELEASED**  
04.03.01  
**DEO ATTACHED**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 66829

*Bl1102-25*

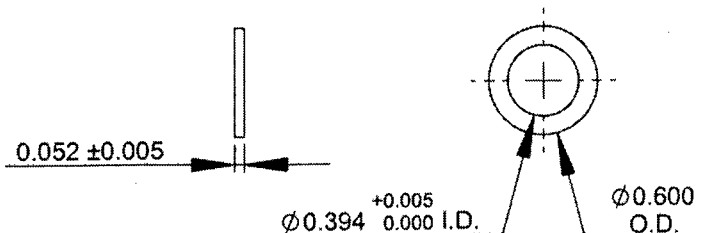


**D3183-041 BRACKET ASSEMBLY (SHOWN)**  
**D3183-042 BRACKET ASSEMBLY (OPPOSITE)**  
**D3183-043 BRACKET ASSEMBLY (SIMILAR)**  
**D3183-044 BRACKET ASSEMBLY (SIMILAR)**



**D3183-5 BEARING:**  
**SPECIFICATION CONTROL DRAWING**

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



**D3183-7 WASHER**

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QA COPY  
ISSUED

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAMMESBURY, ONTARIO, CANADA  REV. C SHEET 2 OF 4  SCALE
CHECKED	APPROVED	
DATE	TITLE	

SEE DETAIL B

4.8°

0.100

0.070 (TYP)

0.182

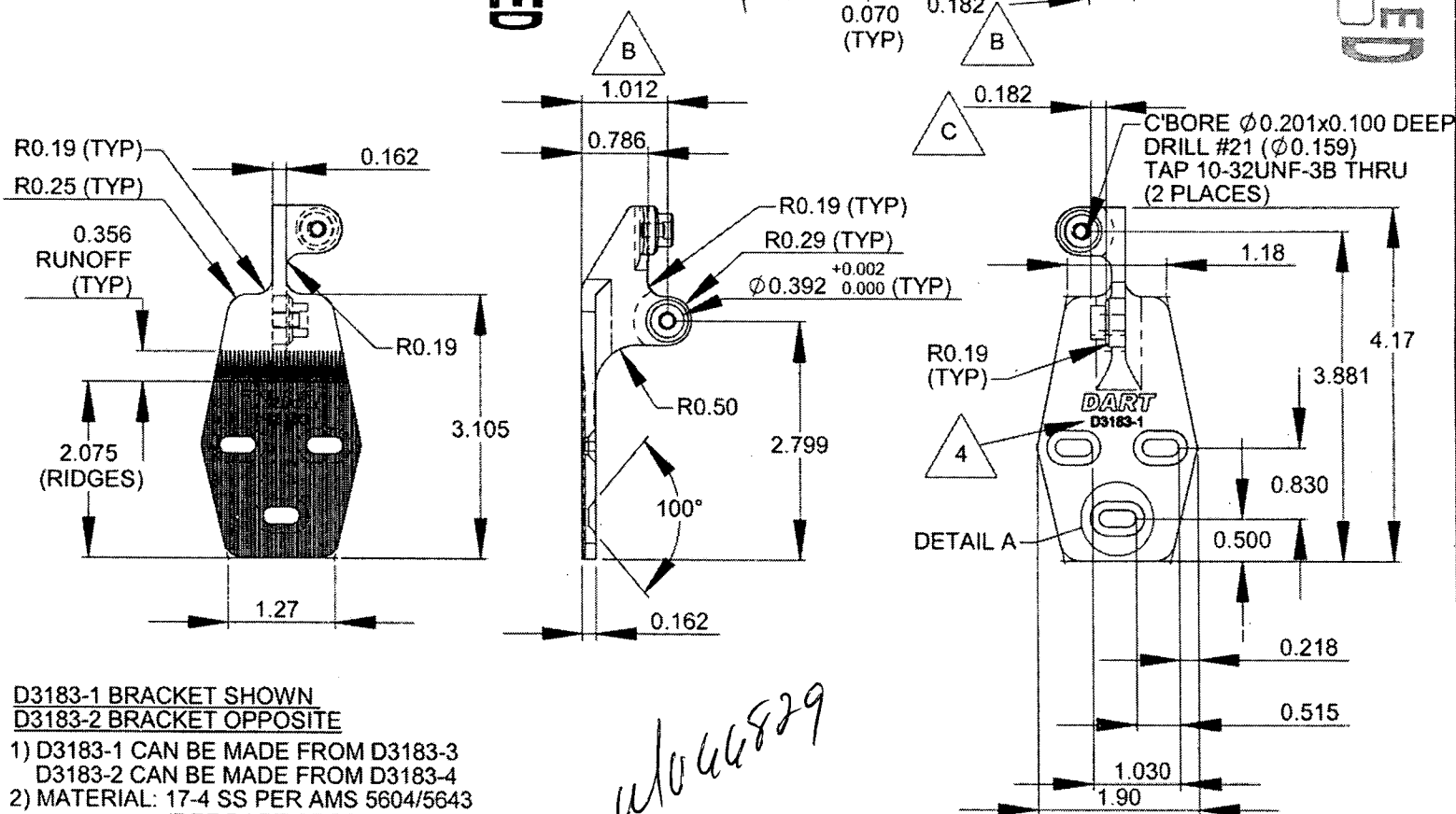
R0.19 (TYP)

R0.063

0.536

B

**DEO ATTACHED**



D3183-1 BRACKET SHOWN  
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3  
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

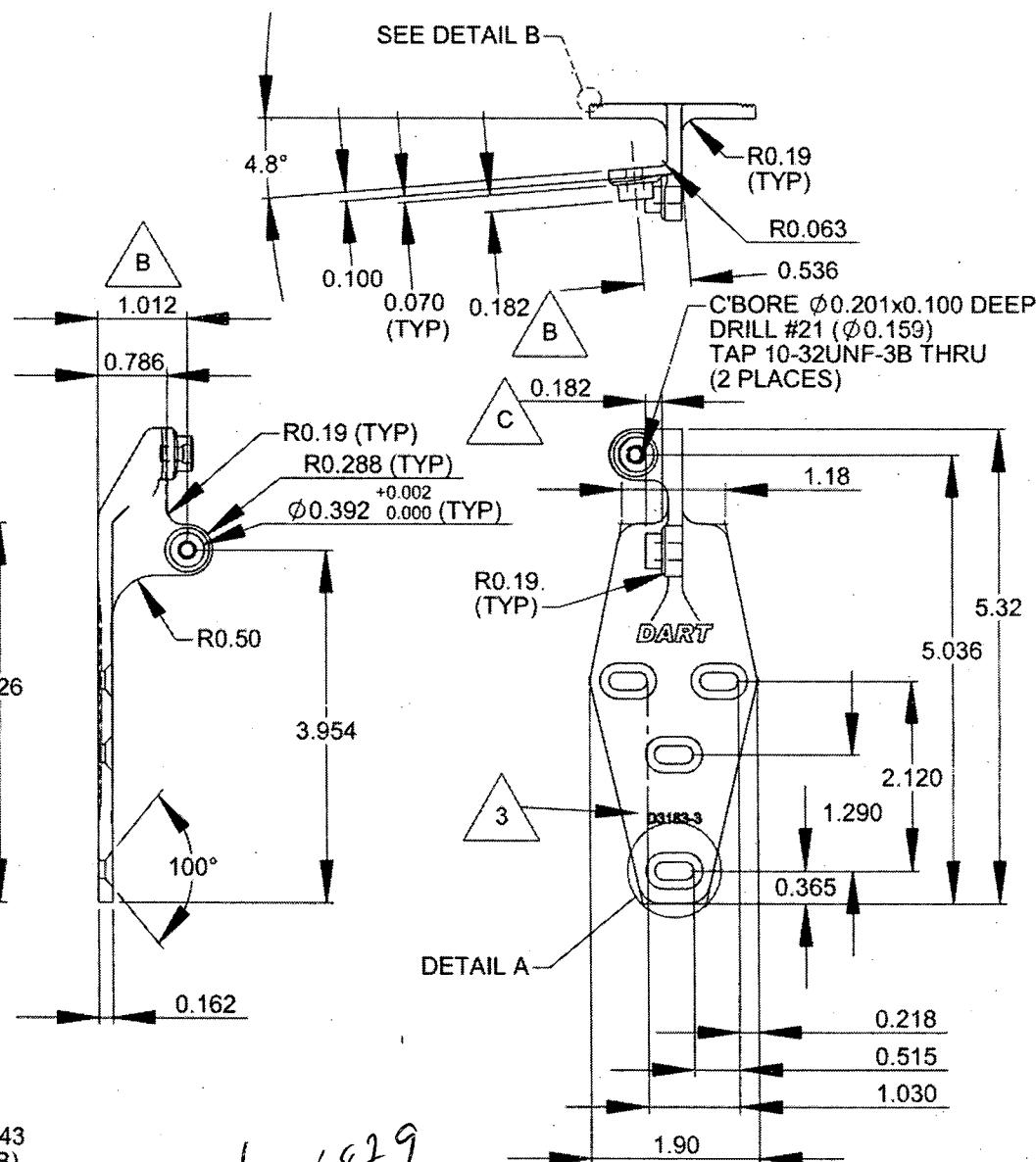
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE 04.02.17	DRAWING NO. D3183	REV. C
	TITLE BRACKET ASSEMBLY	SHEET 3 OF 4
		SCALE 1:2



D3183-3 BRACKET SHOWN  
(REPLACES BELL P/N 412-030-304-105)  
D3183-4 BRACKET OPPOSITE  
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DEO ATTACHED  
RELEASED  
24.03.01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

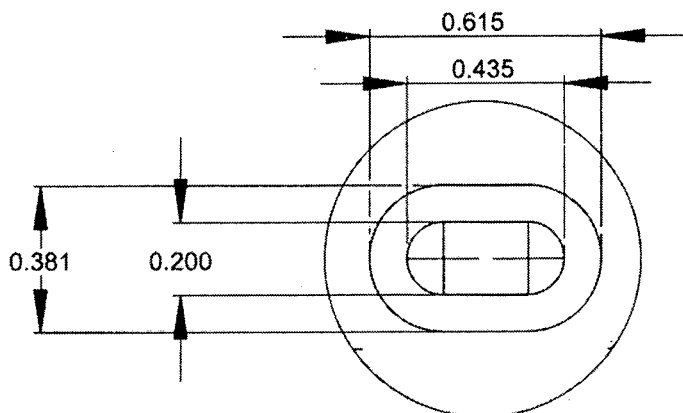
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng				Sign & Date

**NOTE:** Date & initial all entries





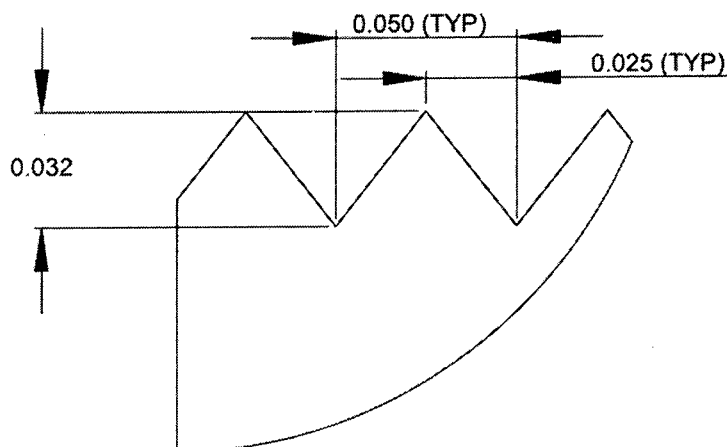
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3183</b>	REV. C SHEET 4 OF 4
DATE <b>04.02.17</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:1



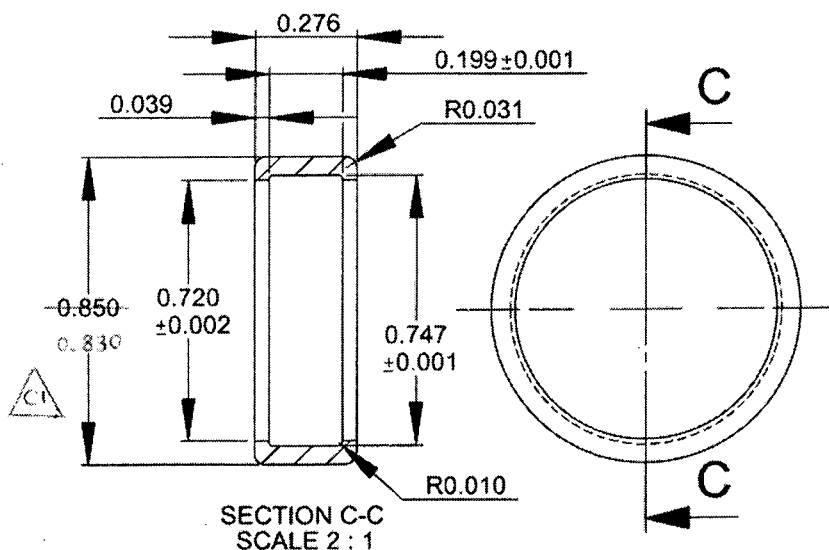
DETAIL A (2 : 1)

RELEASED  
04.03.01

DEO ATTACHED



DETAIL B (20 : 1)



**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00  
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3183-045 BEARING ASSEMBLY**

- 1) ASSEMBLE D3183-5 BEARING AND  
D3183-9 CAP

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng				Sign & Date

**NOTE:** Date & initial all entries